

## WHAT IS CLAIMED IS:

1. A keyless tooling system for the production of continuous seam-welded tubes comprising:

5 a tapered spindle having a tapered outer surface journaled for rotation between front and rear stands of the tube mill;

an expandable tapered bushing juxtaposed on the tapered outer surface of said spindle;

10 a forming roll having a hollow central bore carried by an outer surface of said bushing;

first driver for moving said bushing in a first direction to cause expansion of said bushing between the tapered surface of said spindle and hollow central bore of said forming roll; and

15 second driver for moving said bushing in a second direction to cause contraction of said bushing between the tapered surface of said spindle and hollow central bore of said forming roll.

20 2. The invention defined in Claim 1 wherein said first driver and said second driver actuated by pressure fluid.

25 3. The invention defined in Claim 1 including a source of fluid pressure, a first conduit means coupling said source to said first driver, and a second conduit means coupling said source to said second driver.

4. The invention defined in Claim 1 wherein said expandable tapered bushing is generally cylindrical and is provided with a plurality of a substantially parallel spaced apart slots.

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5. A keyless tooling system for the production of continuous seam-welded tubes comprising:

a tapered spindle having a tapered outer surface journaled for rotation between front and rear stands of the tube mill;

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an expandable tapered bushing juxtaposed on the tapered outer surface of said spindle;

a forming roll having a hollow central bore carried by an outer surface of said bushing;

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first driver for moving said bushing in a first direction to cause said bushing to secure said forming roll to said spindle; and

second driver for moving said bushing in a second direction to cause said bushing to release said forming roll from said spindle.

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6. The invention defined in Claim 5 wherein said first driver and said second driver actuated by pressure fluid.

7. The invention defined in Claim 5 including a source of fluid pressure, first conduit means coupling said source to said first driver and second conduit means coupling said source to said second driver.

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8. The invention defined in Claim 5 wherein said expandable tapered bushing is generally cylindrical and is provided with a plurality of a substantially parallel spaced apart slots.

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9. A keyless tooling system for maintaining a roll on a tapered supporting spindle comprising:

an expandable tapered bushing juxtaposed on the tapered spindle;

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a roll having a hollow central bore carried by said bushing; and

means for moving said bushing in a first direction to cause expansion of said bushing and in a second direction to cause contraction of said bushing.

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